












Date: Thursday, 19/03/2009 11:05:16 AM
User: Julie Dawson

Process Sheet

| | | | |
|---|--|---|--|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID |
| Job Number | : 46578 | Part Number | : D206642312 |
| Estimate Number | : 10552 | Drawing Number | : N/A |
| P.O. Number | : | Project Number | : N/A |
| This Issue | : 19/03/2009 S.O. No. : | Drawing Revision | : L |
| Prsht Rev. | : NC | Material | : |
| First Issue | : / / Type : SKIDTUBES | Due Date | : 15/04/2009 Qty: 1 Um: Each |
| Previous Run | : 46577 | | |
| Written By | : | | |
| Checked & Approved By | : <u>JUL 09.03.19</u> | | |
| Comment | : Est Rev: J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/ EC Est Rev:K 07-12-04 ECN 1080p DD verified by:ec Est Rev:L 08-09-29 as per DSI9421 DD verified by:ec Est Rev:M 09-03-02 as per DSI9440 rev.a verified by: Est Rev:N 09-03-03 as per DSI9421 rev.b verified by: | | |
| Additional Product | | | |
| Job Number:  | | | |
| Seq. #: | Machine Or Operation: | Description : | |
| 1.0 | DC | DOCUMENT CONTROL | |
| |  |  | |
| Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D206-642-312 CHG006 5 09/04/16 | | | |
| 2.0 | PACKAGING 1 | PACKAGING RESOURCE #1 | |
| |  |  | |
| Comment: PACKAGING RESOURCE #1 Pick Packing Kit | | | |
| 3.0 | 46578A | 206 L HIGH GEAR SKIDTUBE | |
| |  |  | |
| 5 Comment: Sub-Component 206L/407 LOW, 407 HIGH GEAR SKIDTUBE 1 x D206-642-341 Batch <u>46578A</u> 88 09/04/16 (x) | | | |
| 4.0 | D206648013 | GHW Modification | |
| |  |  | |
| 5 Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) GHW Modification batch: <u>43410</u> 88 09/04/16 (x) | | | |
| 5.0 | AN4C5A | BOLT | |
| |  |  | |
| 5 Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) BOLT batch: <u>M104936</u> 88 09/04/16 (x) | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 11:05:16 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID

Job Number: 46578

Part Number: D206642312

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960C416

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

washer

batch: M100993

SS 09/04/16 (X)

7.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Ring

batch: 3949

SS 09/04/16 (X)

8.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

BUSHING

Pick:

Qty Part Number Description Batch

16 D2652 Bushing

1 D206-642-341(REF)

45381 (45318)

SS 09/04/16 (X)

9.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

SET SCREW

Pick:

Qty Part Number Description Batch

10 D2712 Set Screw

43810

SS 09/04/16 (X)

10.0

D29322

Saddle RH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

SADDLE

Pick:

Qty Part Number Description Batch

1 D2932-2 Saddle

40280

SS 09/04/16 (X)

11.0

D29332

Saddle RH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

SADDLE

Pick:

Qty Part Number Description Batch

41129

SS 09/04/16 (X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 11:05:17 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID

Job Number: 46578

Part Number: D206642312

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D2933-2 Saddle

12.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SADDLE SPACER

Pick:

Qty Part Number Description Batch

2 D2934 Saddle Spacer

44296

SS 09/04/16 (X1)

13.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SADDLE SPACER

Pick:

Qty Part Number Description Batch

2 D2935 Saddle Spacer

44553

SS 09/04/16 (X1)

14.0

D29382

Saddle RH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty Part Number Description Batch

1 D2938-2 Saddle

41131

SS 09/04/16 (X1)

15.0

D29392

Saddle RH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty Part Number Description Batch

1 D2939-2 Saddle

41441

SS 09/04/16 (X1)

16.0

D3407043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Ring

batch:

43308

SS 09/04/15 (X1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 11:05:17 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID

Job Number: 46578

Part Number: D206642312

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Washer

batch: 43002

88 09/04/15 (X)

18.0

D34571

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

batch: B44603

88 09/04/15 (X)

19.0

MS210434

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Nut

batch: M111177

88 09/04/15 (X)

20.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

Pick:

Qty

Part Number

Description

Batch

8

AN3-41A

Bolt

M111163

88 09/04/15 (X)

21.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

BOLT

Pick:

Qty

Part Number

Description

Batch

12

AN4-6A

Bolt

M109545x6

M110399 x6

88 09/04/15 (X)

22.0

AN510A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Pick:

Qty

Part Number

Description

Batch

4

AN5-10A

Bolt

M110363

88 09/04/15 (X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 11:05:17 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID

Job Number: 46578

Part Number: D206642312

Job Number:



Seq. #:

Machine Or Operation:

Description :

(or AN5-11A)

Choice of bolt will depend on crosstube

23.0

AN511A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty Part Number Description Batch

4 AN5-11A Bolt

(or AN5-12A)

Choice of bolt will depend on crosstube

M110363

88 09/04/15 (X1)

24.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Pick:

Qty Part Number Description Batch

8 AN960JD10

Washer

M110523 x5
M110985 x3

88 09/04/15 (X1)

25.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

WASHER

Pick:

Qty Part Number Description Batch

24 AN960JD416

Washer

M110363

88 09/04/15 (X1)

26.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Pick:

Qty Part Number Description Batch

8 AN960JD516

Washer

M110523

88 09/04/15 (X1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 11:05:17 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID

Job Number: 46578

Part Number: D206642312

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

MS21042L3

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

NUT

Pick:

Qty Part Number

Description

Batch

8 MS21042L3

Nut

M116399

SS 09/04/15 (X1)

28.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

NUT

Pick:

Qty Part Number

Description

Batch

13 MS21042L4

Nut

M109282

SS 09/04/15 (X1)

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

SS 02/04/16 (X1)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-312

Location:

PPP Rev:

F82

9/4/15

(1)

SS

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1)

SS 09/04/15

Job Completion



MF 09-04-18.

46578A

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Monday, 23/03/2009 12:51:29 PM
User: Julie Dawson

Process Sheet

| | |
|---|---|
| Customer : CU-DAR001 Dart Helicopters Services Job Number : 46578 Estimate Number : 10552 P.O. Number : This Issue : 23/03/2009 S.O. No. : Prsht Rev. : NC First Issue : 19/03/2009 Type : SKIDTUBES Previous Run : 46577 Written By : Checked & Approved By : | Drawing Name : 206L/L3/L4/407 LOW, 407 HIGH GEAR SKID Part Number : D206642312 Drawing Number : N/A Project Number : N/A Drawing Revision : L Material : Due Date : 15/04/2009 Qty: 1 Um: Each |
| Comment : Est Rev: J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC Est Rev: K 07-12-04 ECN 1080p DD verified by: ec Est Rev: L 08-09-29 as per DSI9421 DD verified by: ec Est Rev: M 09-03-02 as per DSI9440 rev.a verified by: Est Rev: N 09-03-03 as per DSI9421 rev.b verified by: | |

REFERENCE ONLY

Additional Product

Job Number:



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|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
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| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



JW 09.04.16

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-312 CHG006

S0104196

| | | |
|-----|-------------|-----------------------|
| 2.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|

**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

| | | |
|-----|--------|--------------------------|
| 3.0 | 46578A | 206 L HIGH GEAR SKIDTUBE |
|-----|--------|--------------------------|

**Comment:** Sub-Component 206L/407 LOW, 407 HIGH GEAR SKIDTUBE

1 x D206-642-341 Batch

Job Completion

